

Date: Wednesday, 4/26/2006 7:13:40 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID		
Job Number	: 26844B					
Estimate Number	: 10193					
P.O. Number	: N/A					
This Issue	: 4/26/2006 S.O. No. : N/A		Part Number	: D2512		
Prsht Rev.	: NC		Drawing Number	: D2512 REV D2		
First Issue	: N/A		Project Number	: N/A		
Previous Run	: 26595B		Drawing Revision	: D2		
Written By	: See COMMENT BELOW		Material	: N/A		
Checked & Approved By	: See APPROVE USER & DATE		Due Date	: 5/3/2006		
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21			Qty:	1	Um: Each
EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s) Pick: 3/4"x3/4" 304/316 SS tube .063" wall Batch: M100748 → 518,53"	CPL 06.05.01
2.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3166-3 Basket Hoop B26382	CPL 06.05.01
3.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2506 Label Plate B26631	CPL 06.04.27
4.0	D23271	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2327-1 Bushing B24873	CPL 06.04.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350/212/130 BASKET LID

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Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	<u>325238</u>

CPL 06-04-27

6.0 D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	<u>B26204</u>

CPL 06-04-27

7.0 M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	<u>M100722</u>

CPL 06-05-02

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

CPL 06-05-10

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

~~4-D2012-117 is included in D3172-041 EC130 Basket Base BOM.~~

~~EC130 Basket only~~

Pick:

Qty	Part Number	Description	Batch
2	D2012-117	Clevis	<u> </u>

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Seq. #: Machine Or Operation:

Description :

9.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



J
06-05-10

Q10

Comment: DDIMENSIONAL & WELDING INSPECTION

ID 06-05-10

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 06-05-10

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Wing walk
Batch: 7100652 Spray Paint
BM176415

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: Reva

6/1/12 6

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1
D 06-05-18

Job Completion



6 06-05-18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
0605-10	8	<i>to much</i> too much heat: weld when welding on the label plate. this resulted in a rough (wavey) finish on the outside where the label goes.		<i>Strength wise lid is very good. Appearance on finish not so much. Part is acceptable this time only. Next lid will have more direct heat; less weld, to prevent this.</i>		<i>Z</i> 0605-15		<i>Z</i> 0605-15

NOTE: Date & initial all entries